

Date: Monday, 7/9/2007 1:41:24 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 33419	
Estimate Number : 10314	
P.O. Number : <i>N/A</i>	Part Number : D265613
This Issue : 7/9/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>MA</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 32653	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/25/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: F 02.10.25 Re-format KJ/RF	
Est Rev:G Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.8500 sf(s)/Unit Total : 17.0000 sf(s)
 1010/1025/A21/6aA SHEET *M104921* *IB 07-07-26*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D*
 Prog Rev: *D*

IB 07-07-26



2-Deburr if necessary

*SAA**07/07/30**20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-07-26

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/07/27



5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

FF 07-08-07

FF 07-08-08

*20**20*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/18/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARSHOE

Job Number: 33419

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
En 07/08/08 (x20)

7.0

POWDER COATING

POWDER COATING



M1 104846



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-h

07/08/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/09 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-15

BR

07-08-10

20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20)
07/08/10

Job Completion



C 207/08/10

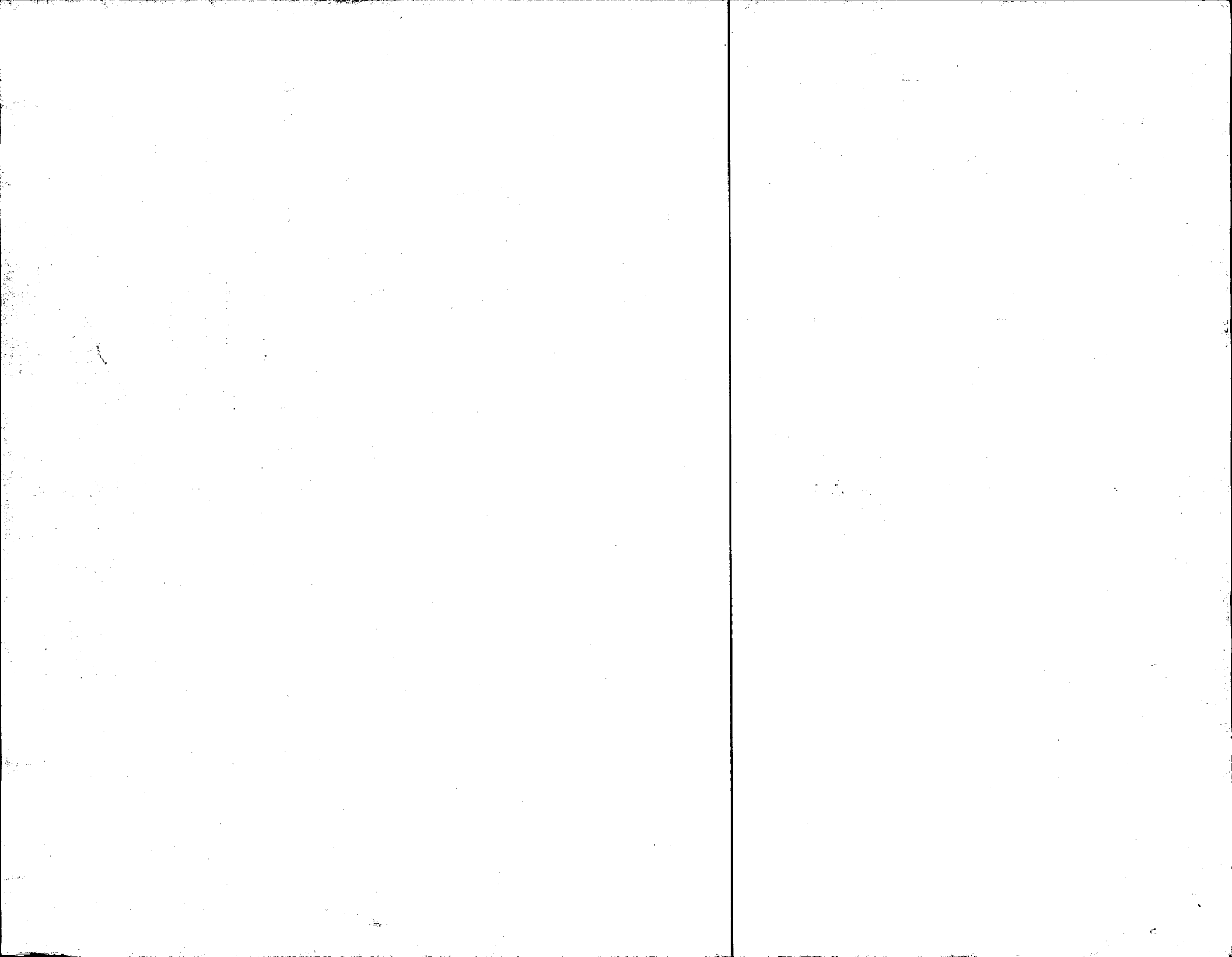
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

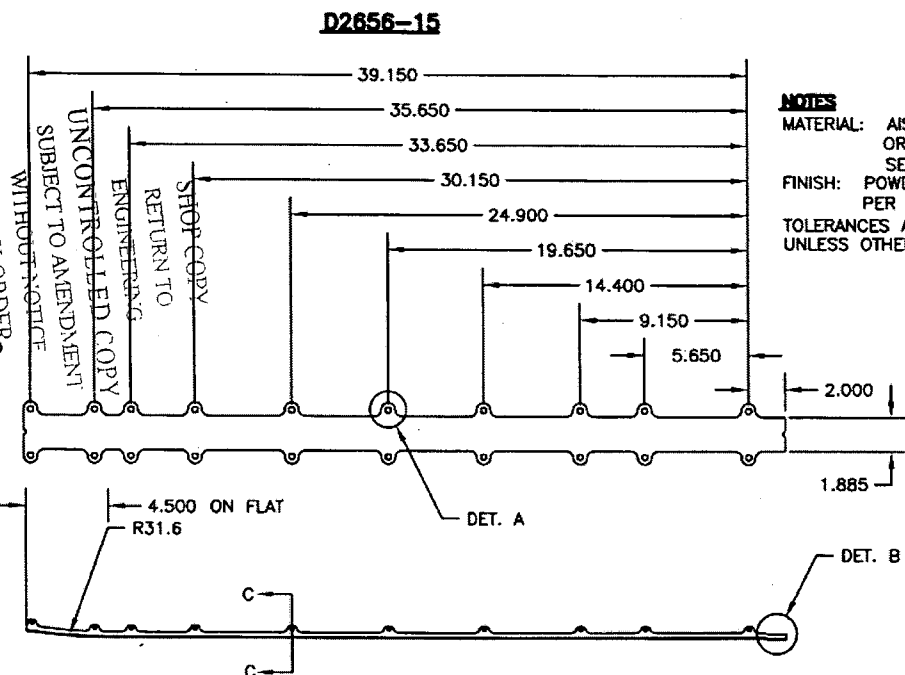
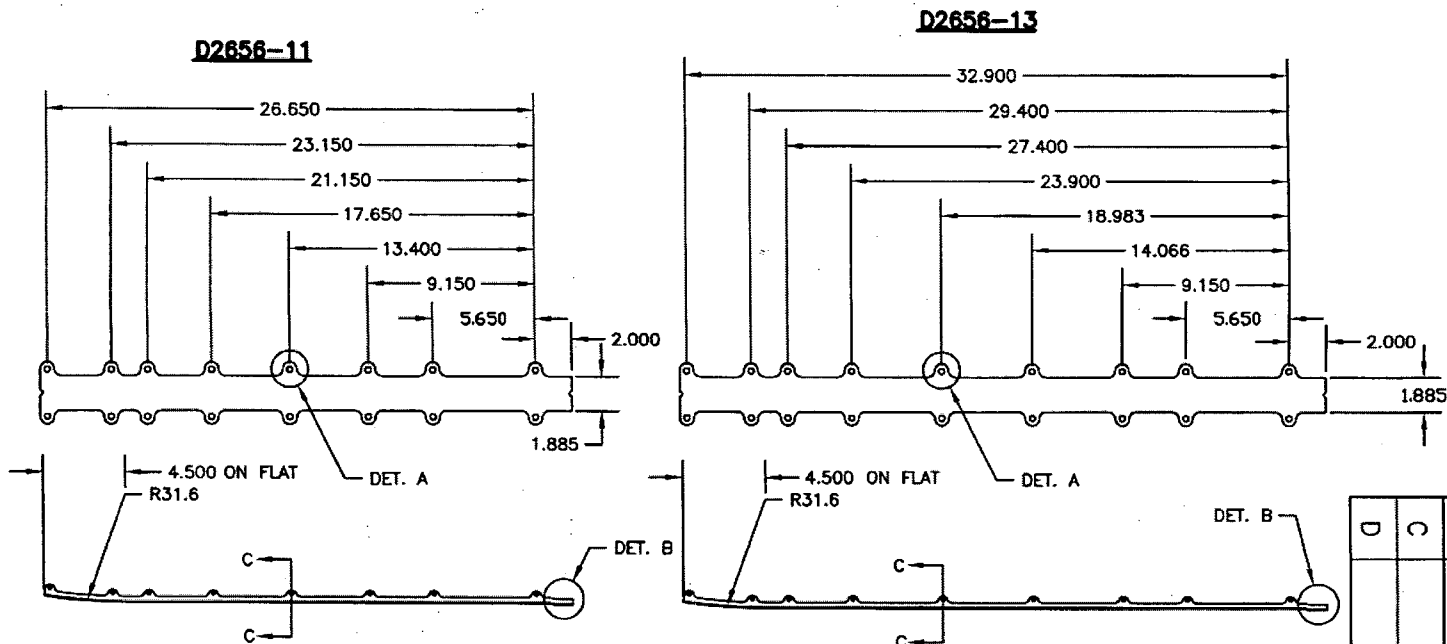
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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				D2656	SHEET 1 OF 4
DATE			TITLE	SCALE	
05.08.17			WEARSHOE	1:10	
A		97:03:25	NEW ISSUE		
B		97:06:02	CHANGED TABS		
C		97:06:26	R31.6 WAS R19.5		
D		05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3

TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

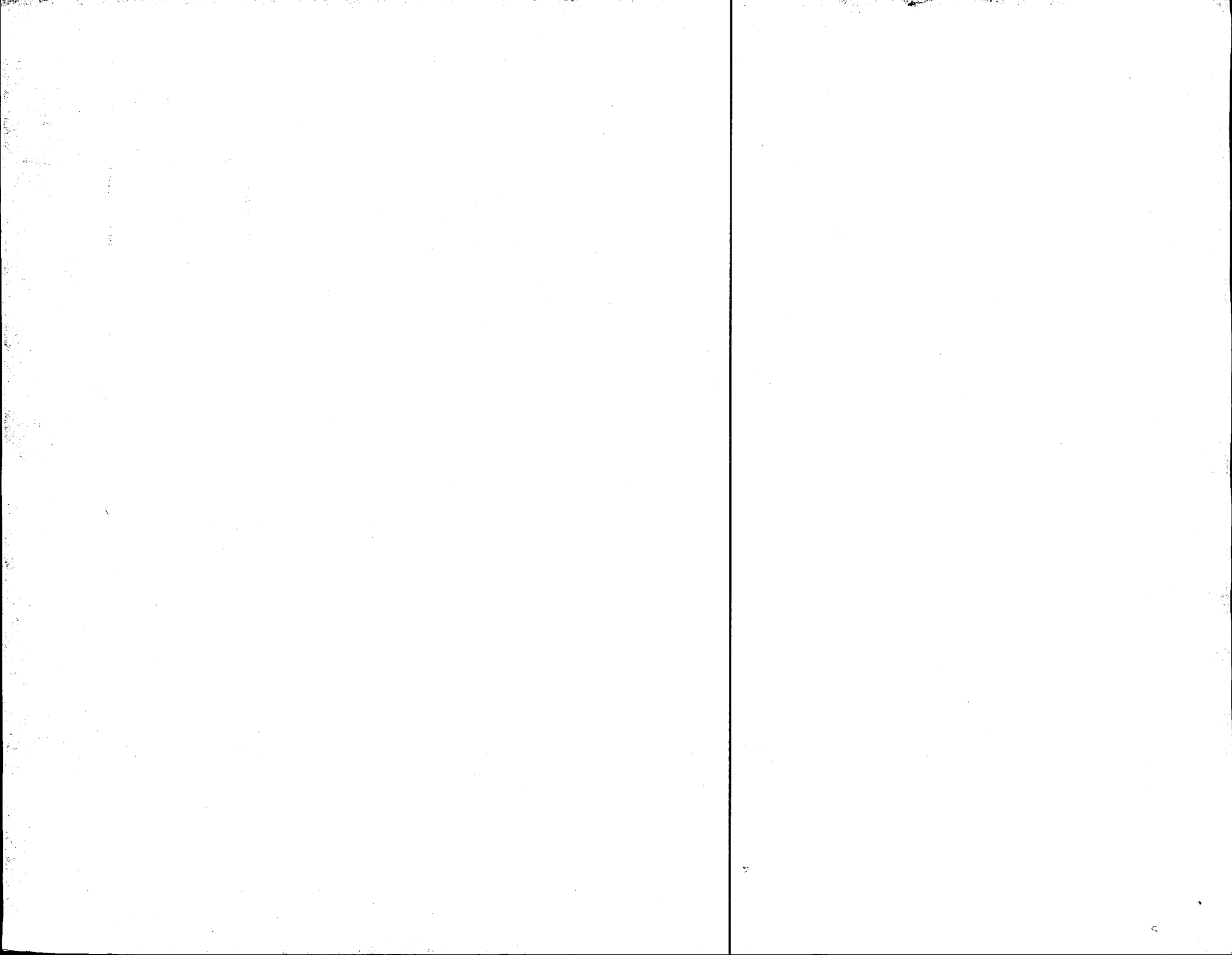
05-09-08

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NO. 33419

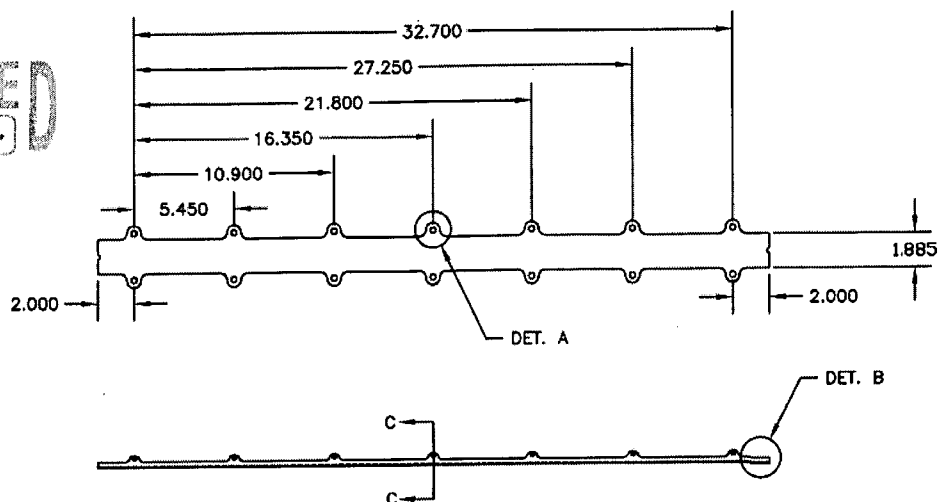




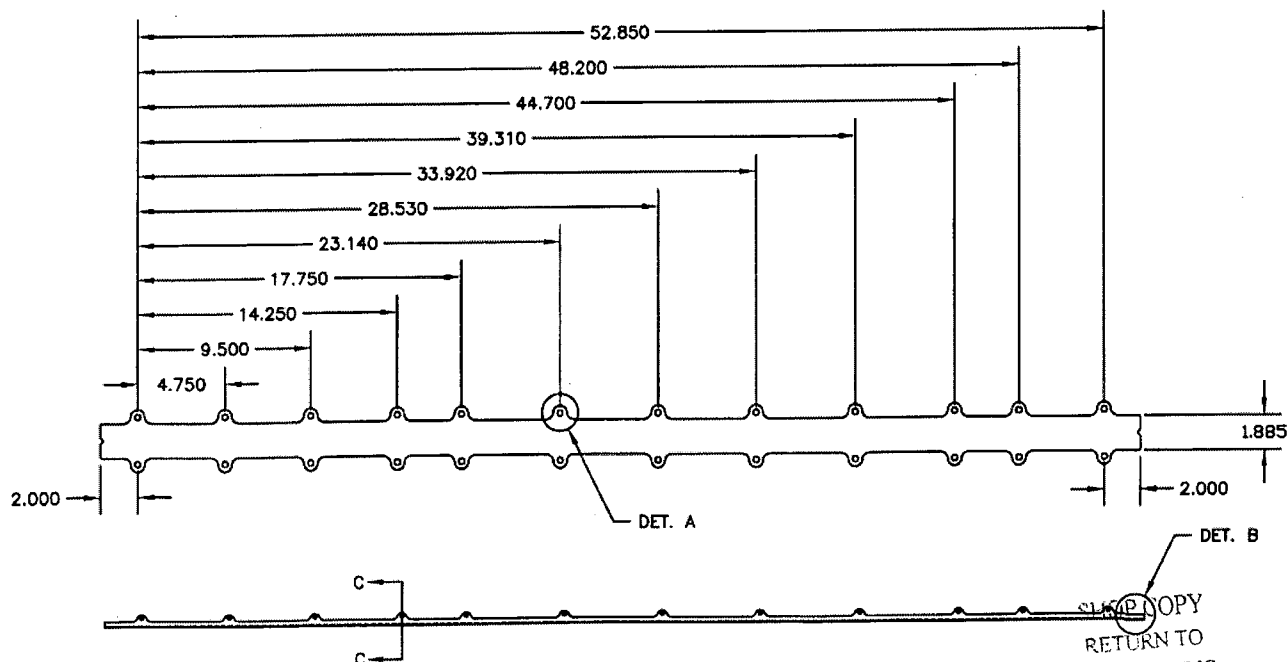
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
DS-07-06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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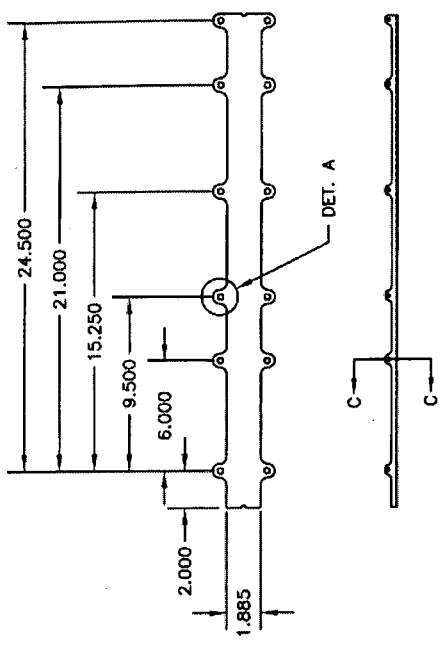
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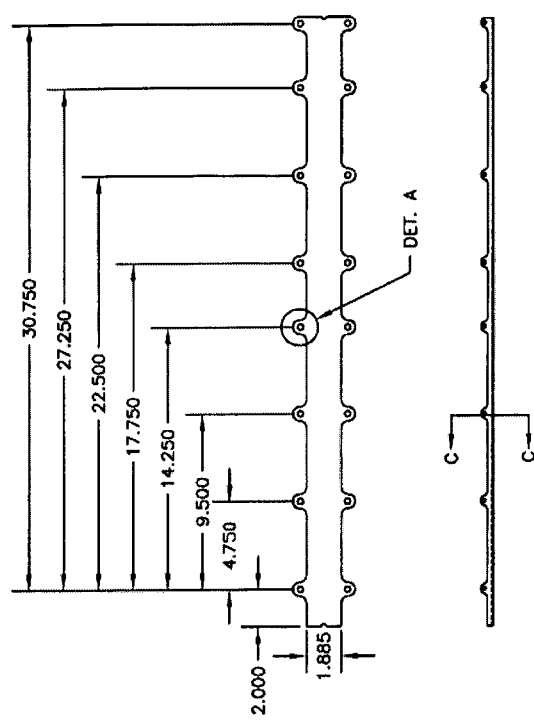


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DATE 05.08.17		TITLE WEARSHOE SCALE 1:10	

D2656-33

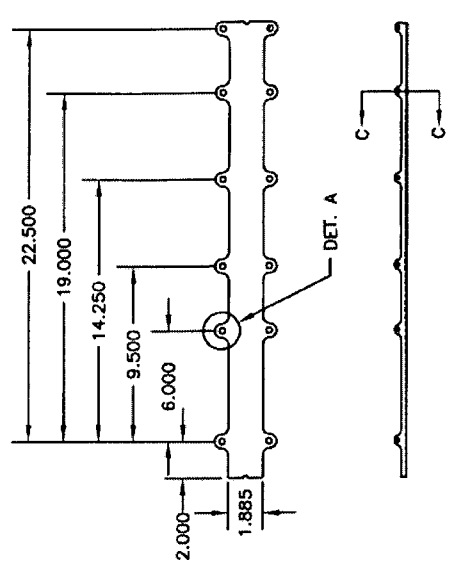


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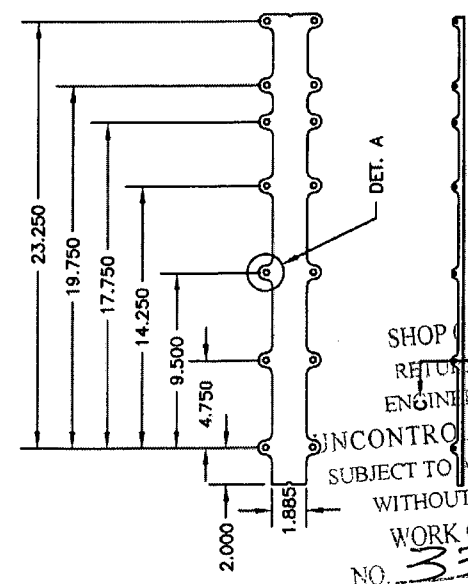


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D2656-35

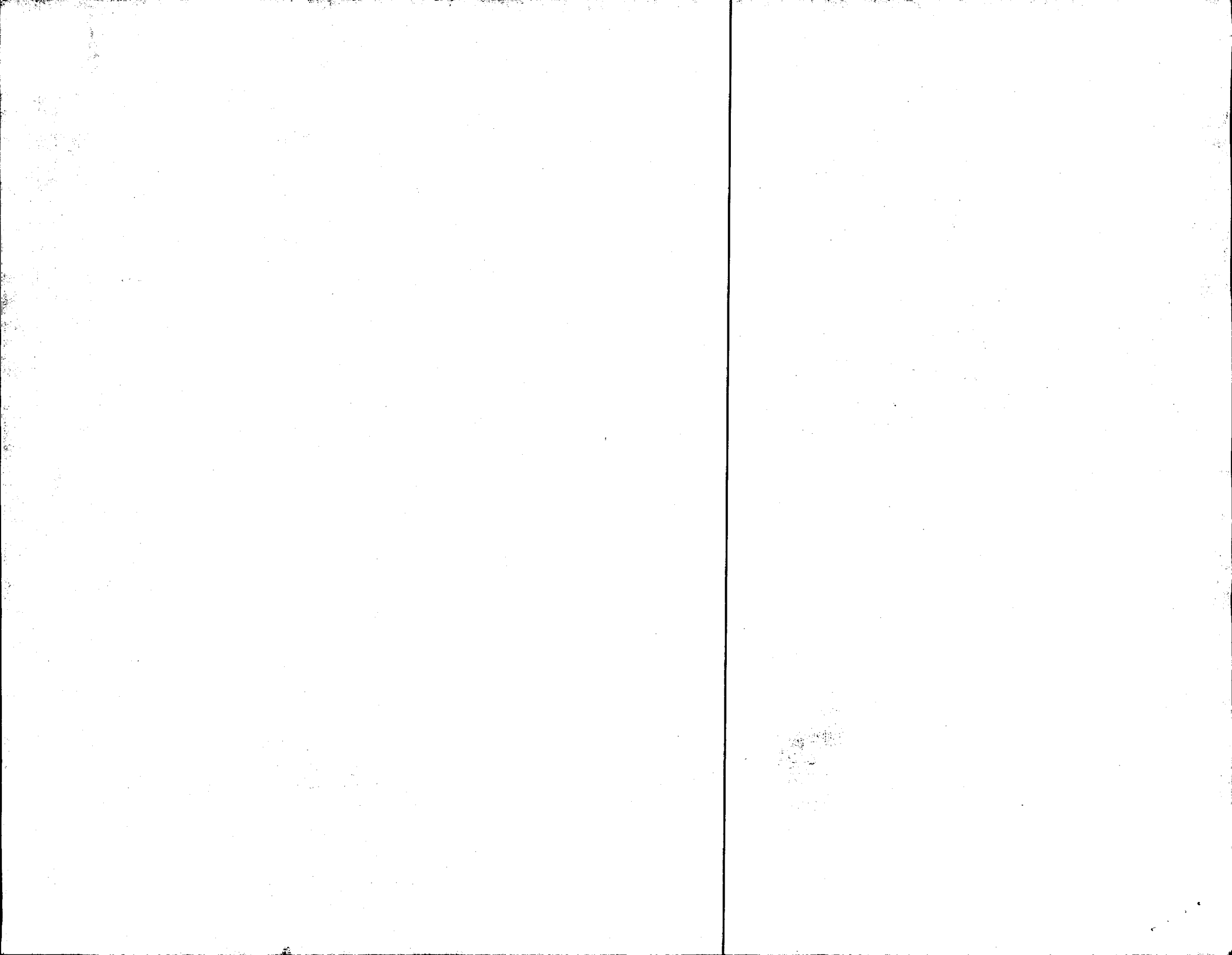


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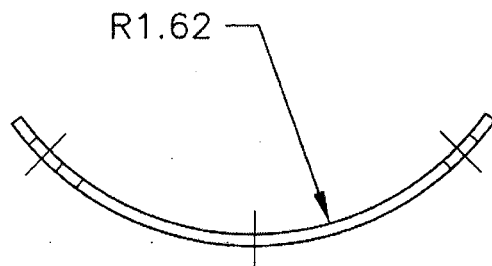
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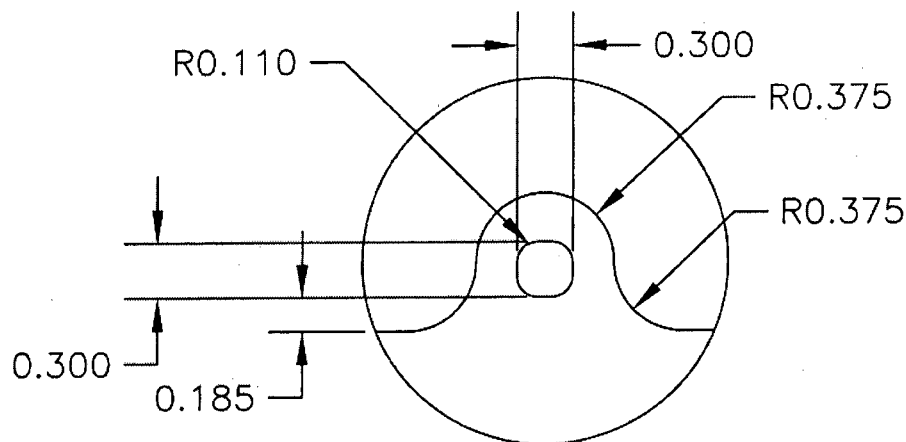
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

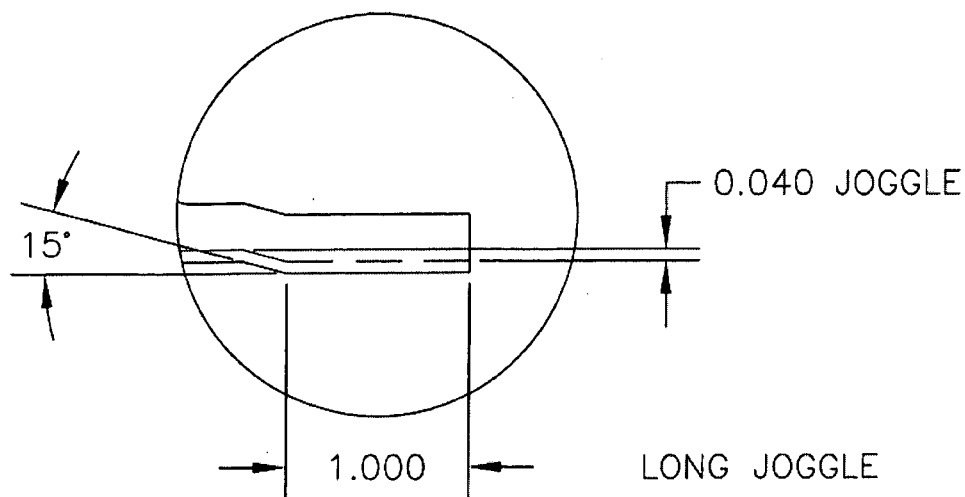


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05.09.06

DETAIL A



DETAIL B



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